



Commercial Performance Coatings

ZNP-504

CPC 83

Organic Zinc Primer (Kit)

PRODUCT DESCRIPTION	
ZNP-504A ORGANIC ZINC PRIMER Component A	ZNP-504B ORGANIC ZINC HARDENER Component B
ZNP-504Z ORGANIC ZINC POWDER Component C	
<p>TYPE: Organic Zinc Rich Epoxy</p> <p>RECOMMENDED USE ZNP-504A/ZNP-504B/ZNP-504Z Organic Zinc Primer is a low VOC, three-component sacrificial organic epoxy primer for blasted steel. Can be used for field touch up of shop applied inorganic zinc rich primers prior to application of topcoats. With SSPC-SP10 surface preparation, this product can be used for immersion service when properly applied and topcoated.</p>	
PHYSICAL CONSTANTS	
WEIGHT PER GALLON:*	26.4 lbs +/- 0.5 lbs
PERCENT SOLIDS BY WEIGHT:*	87.1% +/- 2%
PERCENT SOLIDS BY VOLUME:*	68.6% +/- 2%
<p>FLASH POINTS: ZNP-504A 61°F (16°C) ZNP-504B 57°F (14°C) ZNP-504Z Not Applicable</p> <p>VOC: 3.4 lbs/gallon (maximum)</p> <p>SHELF LIFE: 36 months</p>	
* Data calculated on mixed formula practical volume solids	
PERFORMANCE FEATURES	
Color:	Gray with Red Cast
Gloss @ 60° Angle:	Matte
Adhesion:	5B - Excellent
Abrasion Resistance:	Excellent
Topcoats:	AUE-100, AUE-300, AUE-360
STEEL: Non-Immersion Service:	The minimum surface preparation for ferrous metal substrate is SSPC-SP6 Commercial Blast cleaning, NACE Number 3. Service life of coating is in direct proportion to surface preparation.
Immersion Service	Near White Metal Blast SSPC-SP10, NACE Number 2 is minimum for ferrous metals. The surface to be coated must be clean dry and well prepared to receive coating.
CHEMICAL/SOLVENT RESISTANCE	
Solvent Resistance	Good
1000 Hours Humidity Resistance	Excellent
2000 Hours Salt Spray Resistance	Excellent

SURFACE PREPARATION

Surface preparation must meet SSPC-SP6 Commercial Blast minimum and SSPC-SP10 for immersion service.

Metal	Recommended Primers	Direct To Properly Treated Substrate
Ferrous metals	Zinc primer/Epoxy midcoat/ Urethane system for extreme performance requirements.	Excellent

The appearance of the topcoat can be optimized by applying a mist coat followed by a full wet coat.

APPLICATION DATA

MIXING DIRECTIONS

This product is supplied as a kit. Mix ZNP-504A (Component A) under mechanical agitation. Add ZNP-504B (Component B) and mix well. Slowly add ZNP-504Z (Component C) zinc powder under agitation. Strain through a 60-mesh screen. Agitation must be maintained throughout mixing and application. Allow it to digest 30 minutes prior to application.

THINNING

Xylene: No more than 3%

POT LIFE

24 Hours at 77°F

RECOMMENDED WET FILM BUILD

Spray Application: 5.5 – 7.5 mils

RECOMMENDED DRY FILM BUILD

3.0 - 4.0 mils

Film in excess or below these recommended film builds might cause problems such as: adhesion failure, pigment floatation, solvent popping.

DRYING TIME

Air-dry at 77°F

Dry to Touch: 1 hour

Dry to Handle: 4 hours

To Recoat: 16 hours

No maximum recoat time; as long as the surface is clean and free of dirt and contaminants

Drying time listed may vary, depending upon film build and temperature.

Application of film thickness in excess of that recommended for this product will substantially extend dry time.

RECOMMENDED SPREADING RATE

832 SQ. FT at 1.0 mil dry film per U.S. Coverage figures do not include losses due to mixing, transfer or application of coating or losses due to surface irregularity.

CLEAN UP

Xylene

APPLICATION PRECAUTIONS AND LIMITATIONS

Do not apply at temperature below 50°F. Curing slows below 60°F. In –Service temperature: Dry heat - 500°F / Wet heat - 150°F.

Lack of agitation will result in poor pigment dispersion and settling. Brush and roller application is not recommended

Changes in application equipment, pressure and or tip sizes may be required depending on ambient temperatures and application conditions. **Note:** Product must cure for a minimum of 7 days @ 70°F before being subjected to immersion service.

APPLICATION METHOD:

Air Spray:

DeVilbiss MBC-510, 64 air cap with “E” tip and needle or equivalent equipment. Agitated pressure pot with a maximum of 25 ft. 5/16 inch (7.94mm) I.D. air and ½ inch (12.70) I.D. fluid hose. Atomization pressure 50 psi, fluid pressure 15 psi.

Airless Spray:

Use equipment recommended by the manufacture as suitable for application of zinc rich coatings. Continuous agitation of mixed materials is required during application. Equipment must be capable of maintaining a minimum of 1500 psi at the tip without surge.

To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries, Inc. is constantly improving its coatings and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your PPG Distributor for the most up-to-date information.

SAFETY

These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public.

Safe application of paints and coatings requires knowledge of equipment materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness. Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers. Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.

PRECAUTIONARY INFORMATION

Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

KEEP OUT OF THE REACH OF CHILDREN

MEDICAL RESPONSE

Emergency Medical or Spill Control Information (412) 434-4515. CANADA (514) 645-1320 Have label information available. **MATERIAL SAFETY DATA SHEET: Material Safety Data Sheets for the PPG products mentioned in this publication are available through your PPG Distributor. FOR ADDITIONAL INFORMATION REGARDING THIS PRODUCT, SEE THE MSDS AND LABEL INFORMATION.**

PPG Industries
Commercial Coatings

We're Everywhere You Look